

Ship April 23

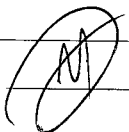
Work Order ID 131641

Monday, April 20, 2015 3:08:23 PM

131641

Page 1

Item ID: D2124 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 4/21/15 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 4/22/15 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan:  Date: 6-14-20 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2124	c								

100
100
 Waterjet
 FLOW CNC Waterjet
 FLOW WATER JET
 Memo
 1-Cut as per Dwg
 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary
 0.00
 0.00
 (6) ———— DL 15/04/20

110
110
 QC
 Quality Control
 QC2- Inspect parts off machine FAI/FAIB
 Memo
 0.00
 0.00
 (6) ———— DL 15/04/20

120
120
 QC
 Quality Control
 QC8- Inspect parts - second check
 Memo
 0.00
 0.00
 (6) ———— DAS 38 9-89 APR 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

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Page 2

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Required Date: 4/22/15 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 NC BRAKE Memo	0.00 0.00				6		15-4-22	QSC
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				6	φ	15-4-23	DAS 34 9-89
150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 11/23480 Memo START TIME: <u>9:20</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>9:50</u>	0.00 0.00				6	0	15-4-23	DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

Work Order ID 131641

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131641

Page 3

Item ID: D2124

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 4/21/15

Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/22/15

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

DAS

30

9-80

APR 23 2015

180

Identify as per dwg & Stock Location: *Ship*

0.00

180

Packaging

Memo

0.00

Packaging

b

DAS
6
9-80

APR 23 2015

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ

15-04-23

MF
15-4-23

DQA: _____ Date: _____



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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Monday, April 20, 2015 3:08:27 PM

Page 1

Work Order ID: 131641

131641

Parent Item: D2124

D2124

Parent Item Name: Bracket

Start Date: 4/21/15

Required Date: 4/22/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 14.12.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063		Purchased	No				sf	198.6680		1			
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M2024T3S 06.3

2024-T3 .063 sheet

DL 15/04/20

Location

Loc Qty

Loc Code

MAT022

198.668

m127866

16

m130525

182.668

13000

1.2

DQA: _____ Date: _____

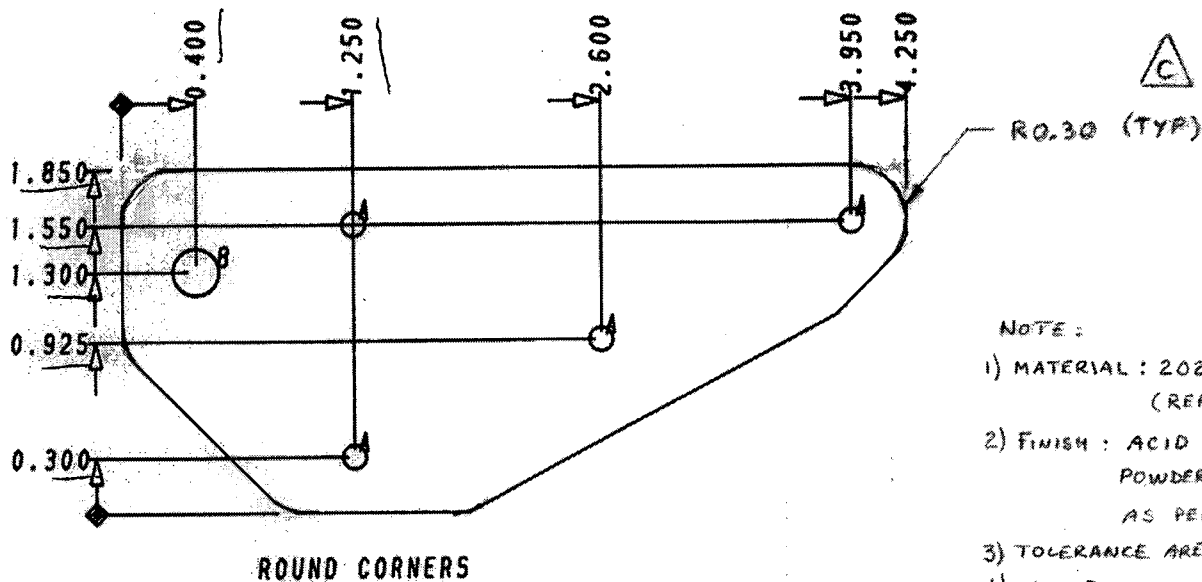


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Misidentified ☐	Past Due ☐																								



- NOTE:
- 1) MATERIAL : 2024-T3 SHEET (QQ-A-250/4) 0.063 THICK
(REF. SPEC M2024T3S.063)
 - 2) FINISH : ACID ETCH AND ALODINE AS PER DART QSI DQS 4.1
POWDER COAT BLACK SANDTEX (REF. 4.3.S.3)
AS PER DART QSI DQS 4.3
 - 3) TOLERANCE ARE PER DART QSI DIB UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
99.05.20 KE



C	B	A	D2124	B	0.250 DIAMETER	1								
03.03.24 RF	09.05.20 RF	92.02.25 DRS		A	0.128 DIAMETER	4								
03.03.25 KE	99.05.10 KE			LTR	SIZE AND DESCRIPTION	QTY								
ROUND CORNERS R0.30 ADDED FINISH SPEC	SQUARE CORNERS TSR A1218	NEW ISSUE												
			DATE	92/02/25	TITLE		BRACKET							
			APPROVED	XYZ	DATE	YY/MM/DD	COMPANY		DART AERO ACCESSORIES					
			LAST REVISED		YY/MM/DD	PROJECT			BATTERY BOX					
			BRAKE PUNCH	XXXX	BRAKE DIE	XXXX	MATERIAL	2024-T3 ALUMINUM	SCALE	TOLERANCE	SIZE	SHEET		
			PEGA NUMBER	0XXX	PEGA DESCRIPTION	PEGANANE	GRADE	14 GA	THICKNESS	0.064	1:1	0.010	A	1
			ALL MEASUREMENTS IN INCHES				FINISH	DEBURRED	DRAWING NUMBER			DA-BRKT-920225		

D2124